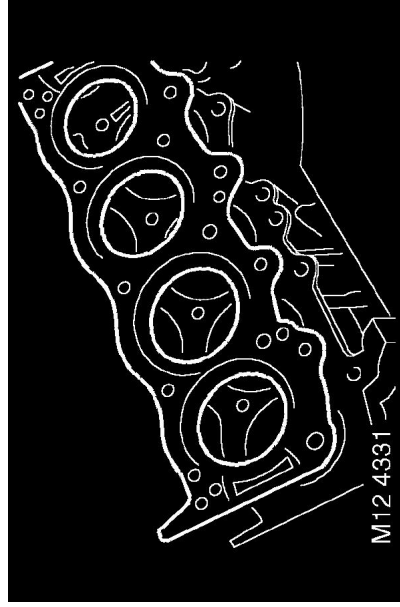


ENGINE - V8



M12 4331

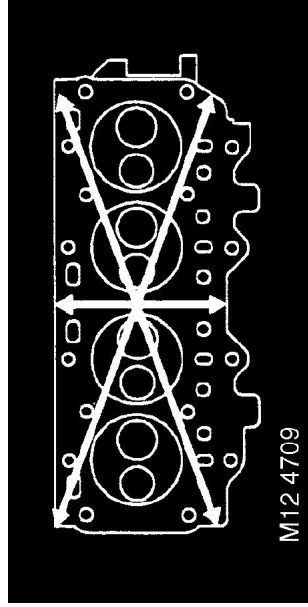
10. Remove cylinder head gasket.

CAUTION: Support both ends of cylinder head on blocks of wood.

Inspect

1. Clean mating faces of cylinder block and head using suitable gasket removal spray and a plastic scraper, ensure that bolt holes in block are clean and dry.

CAUTION: Do not use a metal scraper or machined surfaces may be damaged.



M12 4709

2. Check head and block faces for warping and pitting.
 - Maximum cylinder head warp = 0.05 mm (0.002 in).

Note: Cylinder head can be refaced to 0.50 mm (0.02 in) maximum below head height – See cylinder head overhaul.

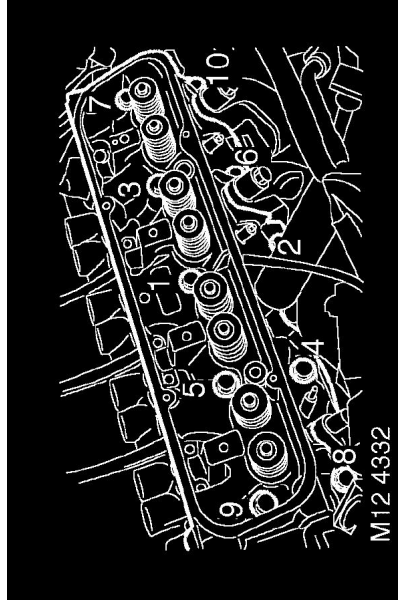
3. **Models with SAI:** Using a 5/8 in x 20 TPI (threads per inch) UNF tap having a class 2A thread, remove deposits from secondary air injection adapter tappings in cylinder head.

CAUTION: Ensure that tap used has 20 TPI.

Reassembly

1. Ensure that cylinder head bolt holes are clean and dry.
2. Fit cylinder head gasket with the word TOP uppermost.

CAUTION: Gaskets must be fitted dry.
3. Carefully fit cylinder head and locate on dowels.
4. Lightly lubricate new cylinder head bolt threads with clean engine oil.



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5. Noting that bolts 1, 3 and 5 are longer than the remainder, fit bolts and tighten in the sequence shown to 20 Nm (15 lbf.ft) then turn through 90 °, then a further 90 °. **CAUTION: Do not tighten bolts 180° in one operation.**
6. **Models with SAI:** Fit new air injection adapters and using a 9 mm hexagonal drive bit, tighten to 33 Nm (24 lbf.ft).

CAUTION: Do not use an air tool to tighten adapters.
7. Clean the push rods, Lubricate ends of push rods with clean engine oil, and fit in their removed order.
8. Clean bases of rocker pillars and mating faces on cylinder head.
9. Clean contact surfaces on rockers, valves and push rods.
10. Lubricate contact surfaces and rocker shaft with clean engine oil.
11. Fit rocker shaft assembly and engage push rods.
12. Fit rocker shaft bolts and progressively tighten to 40 Nm (30 lbf.ft).
13. Connect ht leads to spark plugs in their correct fitted order.
14. **RH cylinder head:** Position alternator mounting bracket, fit bolts and tighten to 40 Nm (30 lbf.ft).
15. **RH cylinder head:** Fit auxiliary drive belt tensioner.
16. Fit inlet manifold gasket.

ENGINE - V8, OVERHAUL, Gasket - inlet manifold.